

5/45

DART AEROSPACE LTD.	Work Order :	24670
Description: 205 Skid Tube 'I' Beam	Part Number:	D2596
Drawing: D2596 Rev C	Qty:	2

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg not required R 03.01.23</i>	HA	05.10.26	2
2	METAL	Cut D2500-3 to length: 99.5" Batch B21570	HA	05-11-3	2
3	METAL	Use Jig DT 8093 to drill pilot holes 30 Open to 0.625" diameter using a uni-bit	Pmc	05-11-3	2
4	METAL	Acid Etch and Alodine per QSI 005 4.1 A.M.	HA	05-11-3	2
5	QC	Level 5 inspection	DP	05-11-10	2
6	STORES	Identify and Stock	DP	05-11-10	2
7	EXPEDITING	Close W/O Cost / part: 29.58 545 05/11/19 (2) 29.75	DP	05-11-16	2

Rev	Date	Change	Revised By	Approved By
B	98.01.19			
C	98.10.15	Eliminated DEO, Changed Dwg Revision	KS	
D	99.02.02	Changed QA to QC, Added Step 6 and Cost	DM	

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9-89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

Authorized Inspector

Date

RELEASED
DM 99.02.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 05/11/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

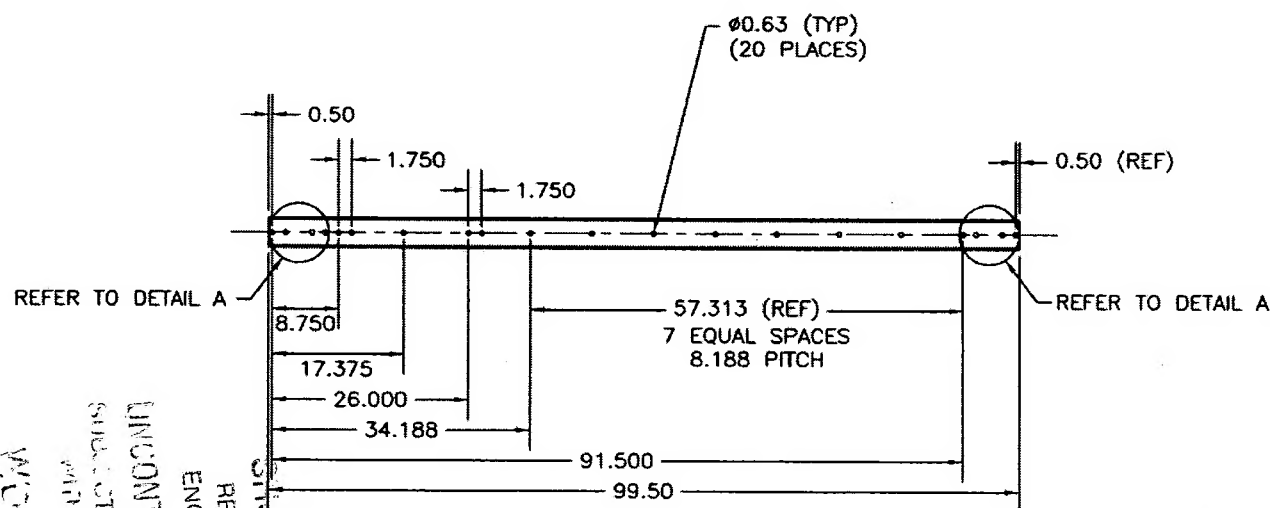
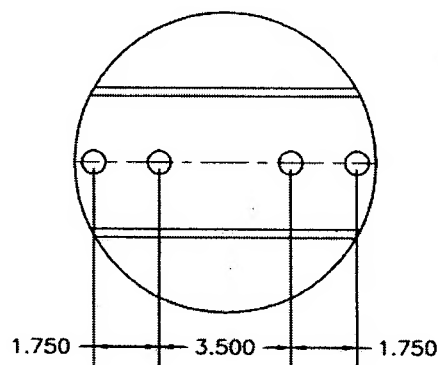
NOTE: Date & initial all entries



RELEASED
98.09.17 bs

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED	APPROVED	DRAWING NO. D2596	SHEET 1 OF 1
DATE 98.09.14	TITLE 205 WEB	SCALE 1:24	
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	

DETAIL A
SCALE 5:24



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO
PART 10

NO. 24670

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 25, 2005
04:04 pm

Work Order No : 0024670
Project Name : D2596
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D2596
Description : 205 Web
Manufactured : Yes
Amount Req'd : 2
Amount Done : 0
Start Date : 10-25-05
Est Finish Date : 11-08-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Friday, 11/11/2005 7:59:32 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 24670		
Estimate Number	: 10346		
P.O. Number	:	Part Number	: D2596
This Issue	: 11/11/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2596 REV C
First Issue	: / /	Project Number	:
Previous Run	:	Drawing Revision	: C
Written By	: _____	Material	:
Checked & Approved By	: _____	Due Date	: 11/18/2005
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M		

Qty: 2 **Um:** Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D25003100	Ext'n - I' Beam Web 4"
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
 		
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.625" diameter using a uni-bit 4- Deburr		
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
 		
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1		
4.0	QC5	INSPECT WORK TO CURRENT STEP
 		
Comment: INSPECT WORK TO CURRENT STEP		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
 		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		
6.0	DC	DOCUMENT CONTROL
 		
Comment: DOCUMENT CONTROL Inspection Level 21		

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:44 pm

Work Order No : 0024670
Project Name : D2596
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D2596
Description : 205 Web
Manufactured : Yes
Amount Req'd : 2
Amount Done : 0
Start Date : 10-25-05
Est Finish Date : 11-08-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	1.00	100.00		
Production Cost :	0.00	15.17	100.00	0.00	15.17
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	15.17	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	15.17			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-15.17)